

AMENDMENTS TO THE CLAIMS

claims 1-3 are being canceled respectively without prejudice or disclaimer of the subject matter therein and new claims 4-5 are being presented as follows:

claims 1-3 (Cancelled)

--4. (new) A method of manufacturing a hollow shaft (b) with a flange (a) at one end thereof, comprising the steps of:

preparing a movable die (17) with an upper recess (17a) on an inside surface thereof and a mandrel (20) at a center position thereof;

placing a fixed die (18) under said movable die (17) with a lower recess (18a) on an inside surface thereof;

inserting a steel pipe (19) between said movable die (17) and said fixed die (18);

clamping said steel pipe (19) in a vertical direction by said movable die (17) and said fixed die (18);

engaging said mandrel (20) into said steel pipe (19); and pressing the steel pipe (19) while performing a shear spinning treatment on an outer peripheral

surface of said steel pipe (19) so as to reduce an outside diameter thereof and to integrally form said flange (a).

5. (new) The method according to claim 4, wherein said disc-shaped flange member (A,A') and said hollow shaft member (B,B') are composed of 0.2 - 0.6 wt% of C, 0.01 - 0.1 wt% of Si, 0.05 - 0.5 wt% of Mn, 0.001 - 0.01 wt% of B, 0.01 - 0.1 wt% of Ti or Nb, with the balance being Fe, and are subjected to a heat treatment upon being combined into an integral body, so as to ensure an improved ductility and thus an improved plastic workability.--